## Work Order ID 61872

Wednesday, September 08, 2010 1:34:31 PM



Page 1

Item ID: D4081-1 Accept Setup Start **Revision ID:** Stop Item Name: Bushing **Start Qty: 24.00 Start Date:** 9/8/2010 **Cust Item ID:** Required Date: 9/13/2010 Req'd Qty: 24.00 **Customer:** Reference: Run Start **Process Plan: Tooling:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ **Tool ID** Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Stamp **Qty** Number **Revision Nbr Draw Nbr** D4081 Α 100 0.00 Hardinge 0.00 Memo Hardinge CNC Lathe Small Turn as per Dwg and Folio FA928 DWG REV: FOLIO REV: 10/08/27 **DEBURR** 110 QC2- Inspect parts off machine FAI/FAIB 0.00

Quality Control

QC

Memo

0.00

Sh 10/09/27

24 \_ \_\_\_\_\_

## Work Order ID 61872

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Item ID:

D4081-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Bushing

**Start Date:** 

9/8/2010

**Start Qty: 24.00** 

Req'd Qty: 24.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Tooling:

Date:

Run Start

Reject

Qty



**Required Date:** 9/13/2010

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop



Insp.

Stamp

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

0.00 0.00

Set Up/ Run Hours

A 10 09 27

Tool ID

Accept

Qty

Reject

Number

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

bl 10-9-27.

Memo

0.00

24. p

140

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

N 10/08/27

## Work Order ID 61872

Wednesday, September 08, 2010 1:34:31 PM



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Item ID:

D4081-1

Accept



Setup Start

Stop



Revision ID:

**Start Date:** 

Item Name:

Bushing

9/8/2010

**Start Oty: 24.00** 

Reg'd Oty: 24.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Start



**Required Date: 9/13/2010** 

OC:

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop

Run

Sequence ID/

Work Center ID

150

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp.

Stamp

Packaging

160

QC

**Quality Control** 

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

## **Picklist Print**

Wednesday, September 08, 2010 1:34:35 PM

Work Order ID: 61872

D4081-1 Parent Item:

Parent Item Name: Bushing



**Start Date:** 9/8/2010

**Required Date: 9/13/2010** 

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP REV:A NEW IISUE 10-05-04 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	12.7860	0.1041	2.629895			

6061-T6 RD Tube .375 x.058W

<b>Location</b>	Loc Oty	Loc Code
MAT014	12.786	
110968	1.416	
111944	9.67	
113718	1.7	

2.8 Pt & word 27

DART AEROSPACE LTD	Work Order: 6/872
Description: Rushing	Part Number: 14081-1
Inspection Dwg: 408 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
	X	First Artic	le _	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	nments
1.22	+.000	1.210			Vel L	21	1-9
				<u> </u>			
0.31	1006	0.315					
0.259	1.006	01.258					
						<u> </u>	w
						<u> </u>	
							-
						<b></b>	
						-	**************************************
		<del> </del>					
				<b></b>		-	<u>,</u>
				<u> </u>		-	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
			<b></b>	-			
				<u> </u>		-	
Measured by:	12	Audited by:	BA		Prototype A	pproval:	N/A
Date: 10/09/27		Date:	10/09	27	and the second s	Date:	N/A
Rev Date	Change			•	R	evised by	Approved

	Date:	10/09/27	Date: 10 09 27	Date:	N/A
Rev	Date	Change		Revised by	Approved
1/64	Date	Onungo		VI/II NA	

SHOP COLL RETURN ) ENGIN'S UNCONTRE SUBJECT TO A D D WITHER NO. 18 12 pf (v 9-08 1.22+0.000 Ø0.31 D4081-1 BUSHING NEW ISSUE Α 10.02.08 NOTES:
1) MATERIAL:6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS4080 OR AMS4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T0.375W.058
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.00 lbs REV. DESCRIPTION DATE BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D4081 MFG. APPR. SHEET 1 OF 1 TITLE APPROVED SCALE BUSHING DE APPR. NTS COPYRIGHT © 2010 BY DARY AEROSPACE LTD
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NOT TO SE USED FOR ANY PURPOSE ON COPIED ON COMMANCATED TO JAIN OTHER PRINSOR DATE 10.02.08 7